

HiFill® J-1200/30 NATLTechmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene***General Information****General**

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	1.4	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	11100	psi	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (0.125 in)	2.7	ft·lb/in ²	ISO 180

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	455 to 480	°F
Middle Temperature	465 to 490	°F
Front Temperature	475 to 500	°F
Nozzle Temperature	475 to 500	°F
Processing (Melt) Temp	475 to 525	°F
Mold Temperature	110 to 150	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

Notes¹ Typical properties: these are not to be construed as specifications.